

Work Order ID 150167

Wednesday, August 24, 2016 11:45:01 AM

150167

Page 1

Item ID: D2010-104

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: ARM

Start Date: 8/16/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: AUG 24 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								

100

0.00

100

NC BRAKE

Brake NC

Memo

0.23

Brake NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727
Identify as D2010-1044 FF OCT 17 2016

110

0.00

110

Small Fab

Small Fab

Memo

0.27

Small Fab

1- Bend as per Dwg D2010 using bending Jig D2010-104T2
2- Deburr ends4 FF OCT 17 2016

120

0.00

120

Small Fab

Small Fab

Memo

0.14

Small Fab

1- flare before installing plug as per dwg D2010
2- Install D2057 plug as per Dwg D20104 FF OCT 17 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
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Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

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Work Order ID 150167

Wednesday, August 24, 2016 11:45:01 AM

150167

Page 3

Item ID: D2010-104

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: ARM

Start Date: 8/16/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 5137

0.00

160

Packaging

Memo

0.01

Packaging

4 DAS 6 9:59 OCT 24 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

Quality Control

16/10/25

16-10-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Wednesday, August 24, 2016 11:45:04 AM

Page 1

Work Order ID: 150167

150167

Parent Item: D2010-104

D2010-104

Parent Item Name: ARM

Start Date: 8/16/2016

Required Date: 8/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.02.17New issueKJ/JLM
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

100

f

109.0441

1.5

6.31579

M304TR0 500W 049

304 RD Tube .500 x .049W

FF OCT 17 2016

Location

Loc Qty

Loc Code

GA002

109.0441

M127937

1.1741

M132872

67.87

M135325

40

6.31579

D2057

Manufactured

No

110

Each

27.0000

1

4

D2057

Plug

FF OCT 17 2016

Location

Loc Qty

Loc Code

GA

27

112928

1

141007

26

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

RELEASED

- NOTES:
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING.
 $\phi 0.500 \times 0.049$ WALL
(REF DART SPEC M304TR0.500W.049) $\triangle$
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART
QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING
WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR DISCLOSED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

